

Date: Friday, 3/30/2007 8:28:27 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 407 FWD X-TUBE  
 Job Number : 31553  
 Estimate Number : 12348  
 P.O. Number : N/A Part Number : D407667105  
 This Issue : 3/30/2007 S.O. No. : NA Drawing Number : D407-667-145 REV B  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LANDING GEAR Drawing Revision : N/A  
 Previous Run : 31055 Material : N/A  
 Due Date : 4/5/2007 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : JA 07.03.30  
 Comment : Est Rev: F 05.09.01 Add holes for compatibility with Bell  
 Skidtubes KJ/JLM

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-105 CHG002

D407-667-105

EL 02/09/05

2.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

PULL FROM STOCK

1 X D407-667-105 B 19138 CHG001

1 X D407-667-105 B CHG001

EL 7-8-9

3.0

D407667105

FWD Crosstube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

FWD Crosstube

~~EL 7-8-9~~

4.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2138 f(s)/Unit Total: 1.2138 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400 (Cut to 6.94") Abrasion Strip

5.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043 Nut Plate

32777

25

07-08-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 3/30/2007 8:28:27 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 FWD X-TUBE

Job Number: 31553

Part Number: D407667105

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number

Description Batch

2 D2873-045

Nut Plate

32802 YR  
~~32802 YR~~

RT 07-08-31

7.0

D28911

Support 2.25 dia



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number

Description Batch

2 D2891-1

Support

N/A

8.0

MS20601AD4W10

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number

Description Batch

14 MS20601AD4W10 Rivet

104093<sup>8</sup>/105057<sup>6</sup>

RT 07-08-26

9.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number

Description Batch

4 MS21920-20

Clamp

N/A  
messie ins failed

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Drill out holes per Dwg D407-667-145 Rev. B  
1-Install abrasion strips as per QSI-035 using DT8579. Note: (3) top holes should be facing up.

2-Install supports and clamps as per Dwg D407-667-145. Torque clamps to 80-100 in lb

3-Install nut plates as per Dwg D407-667-145. Touch-up rivet heads with Imron paint.

RT 07-08-31



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
070813	10-0	Extra hole was drilled on the aft side of the cuff.  R.C. Human error. Mixed up drill jigs during drilling.	OS1042	Add tube to DSI 9346.  Do not package until DSI 9346 is complete.	En 070815  N/A	070804	OS1042	070813

NOTE: Date & initial all entries

Date: Friday, 3/30/2007 8:28:27 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 FWD X-TUBE

Job Number: 31553

Part Number: D407667105

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING  
REPAINT CUFFS

Tach up CUFFS

ml on 08-24

①

13.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

RT 07-08-25

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

15.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch:

M4823425379 (FL)

SP

16.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

Batch:

M10538.21

SP

17.0

AN510A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

Batch:

M104906 M105144

SP

18.0

AN530A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

4 AN5-30A

Description. Batch

Bolt

M19322

SP  
7/8 65

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 3/30/2007 8:28:27 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 FWD X-TUBE

Job Number: 31553

Part Number: D407667105

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

18 AN960JD516

Washer

4104488

78/28 SP

20.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Er 07/09/05

See PRO  
AT step  
10.0  
POSITIVE  
RECALL

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D407-667-105

Location:

PPP Rev:

D

07/09/05 (V)

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/09/05

Job Completion



POSITIVE RECALL

EFFECTIVE 07/08/13 AUTH

RELEASED DATE

07/09/05

07/08/13

07/08/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	31553
<b>Description:</b> Crosstube Assembly	<b>Part Number:</b>	D407-667-145
<b>Inspection Dwg:</b> D407-667-145 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

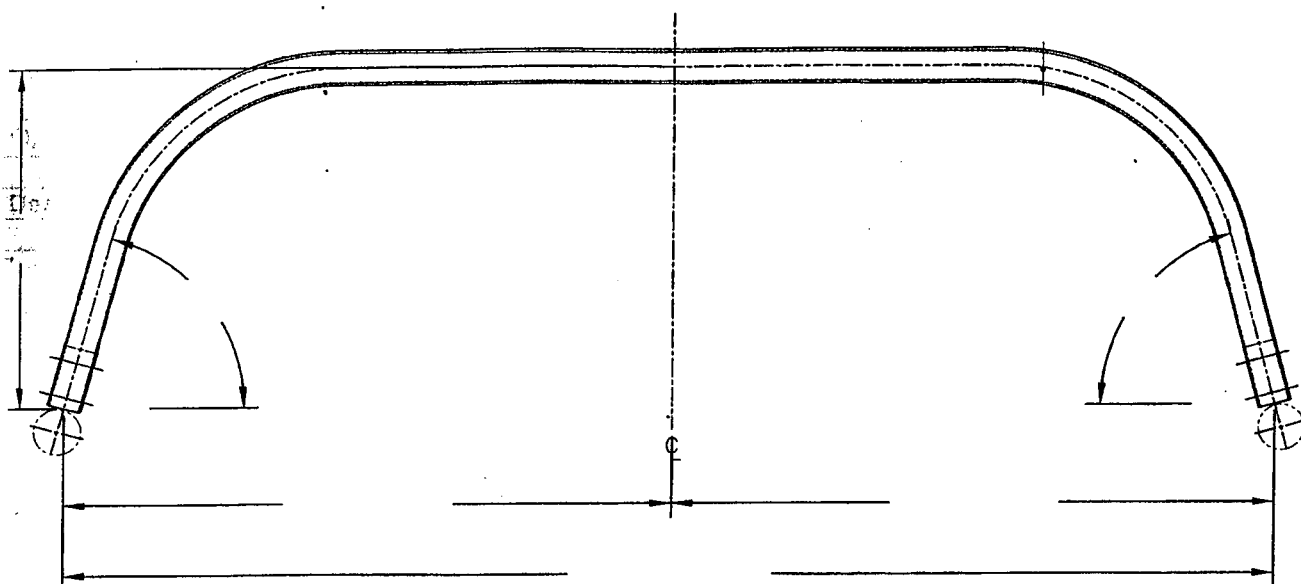
Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000				
	1.865	+0.005/-0.000				
	1.878	+0.005/-0.000				
	1.970	+0.005/-0.000				
	2.030	+0.005/-0.000				
	2.165	+0.005/-0.000				
	0.125	+/-0.010				
	R0.063	+/-0.010				
	R0.500	+/-0.010				
	R0.063	+/-0.010				
	4.438	+/-0.010				
SIDE B	2.240	+0.005/-0.000				
	1.865	+0.005/-0.000				
	1.878	+0.005/-0.000				
	1.970	+0.005/-0.000				
	2.030	+0.005/-0.000				
	2.165	+0.005/-0.000				
	0.125	+/-0.010				
	R0.063	+/-0.010				
	R0.500	+/-0.010				
	R0.063	+/-0.010				
	4.438	+/-0.010				
	113.20	+/-0.020				

<b>Measured by:</b>		<b>Audited by:</b>		<b>Prototype Approval:</b>	N/A
<b>Date:</b>		<b>Date:</b>		<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.21	New Issue (P/O D407-667-105)	KJ/RF	
B	06.03.09	Dwg Rev updated	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	31553
<b>Description:</b> Crosstube High Fwd (407)		<b>Part Number:</b>	D407-667-105
<b>Inspection Dwg:</b> D407-667-145 <b>Rev:</b> B		<b>Page 1 of 1</b>	

Required Dimension	Min	Max
Height	23.48	23.60
1/2 Span	45.88	46.0
Angle	54	56
Total Span	91.76	92.0



Comments

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	<i>[Signature]</i>

**DART**

DESIGN PH	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <del>PH</del> DS	APPROVED <del>PH</del> DS	DRAWING NO. D407-667-145	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (407 HIGH FWD)	SCALE NTS
A	02.05.08	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED  
05.07.26**UNDER REVIEW**06.08.08  
re-draw detailPH  
07.03.00

Qty	Part Number	Description
X	D407-667-145	CROSSTUBE ASSEMBLY (407 HIGH FWD)
1	D6010-115	CROSSTUBE
2	D2856-400-694	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2891-1	SUPPORT
14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
4	MS21920-20	CLAMP

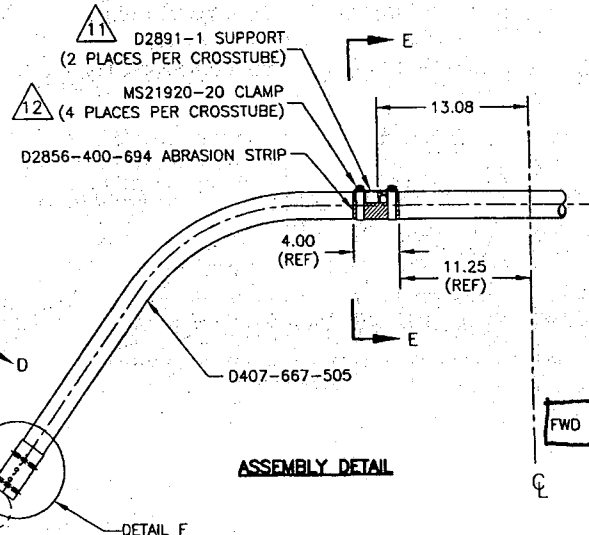
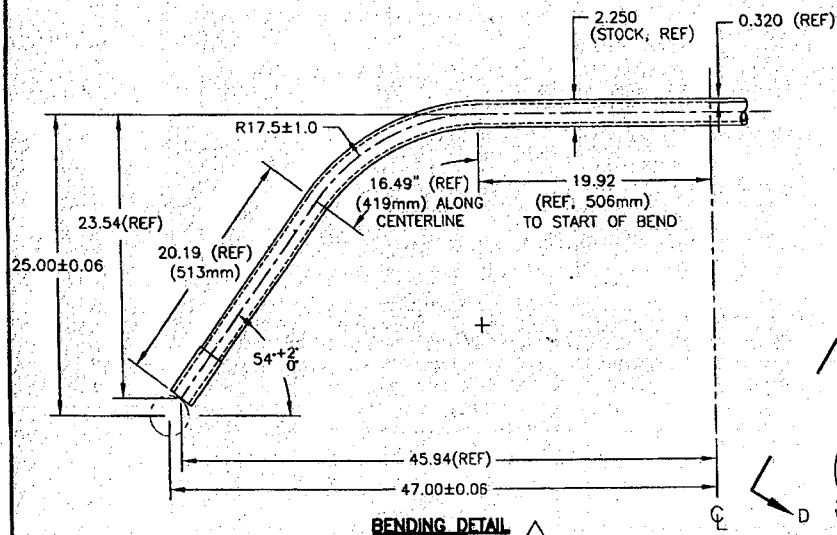
**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6010-115  
FINISHED LENGTH =  $113.20 \pm 0.020$
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT (OPTIONAL).
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

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WITHOUT NOTICE  
WORK ORDER  
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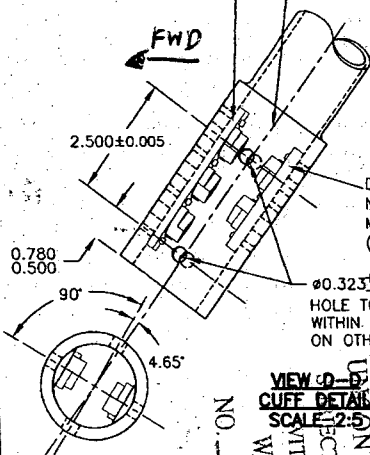
**B**  $\phi 0.323^{+0.005}_{-0.000}$   
(TYP 5 PLACES PER CUFF)  
HOLE TO BE ALIGNED WITHIN  $\pm 0.001$   
OF HLE ON OTHER SIDE OF CUFF

PILOT  $\phi 0.128$   
C'SINK  $\phi 0.225 \times 100$   
(TYP 7 PLACES PER CUFF)

FWD SIDE ONLY  
DETAIL F  
SCALE 2:5

**UNDER REVIEW**  
05.07.26  
07.03.30

D2873-043  
NUT PLATE (1)  
MS20601AD4W10 RIVET (4)  
(1 PLACE PER CUFF)



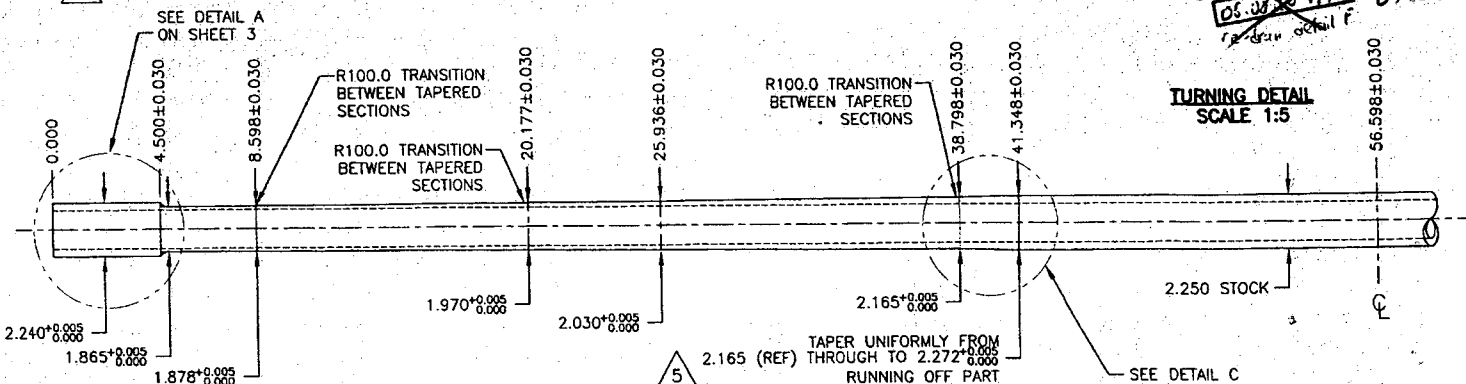
D2873-045  
NUT PLATE (1)  
MS20601AD4W10 RIVET (3)  
(1 PLACE PER CUFF)

$\phi 0.323^{+0.005}_{-0.000}$   
HOLE TO BE ALIGNED  
WITHIN  $\pm 0.001$  OF HOLE  
ON OTHER SIDE OF CUFF

MS21920-20 CLAMP (REF)  
D2891-1 SUPPORT (REF)

**SECTION E-E  
SCALE 2:5**

**9** D2856-400-694 ABRASION STRIP (REF)

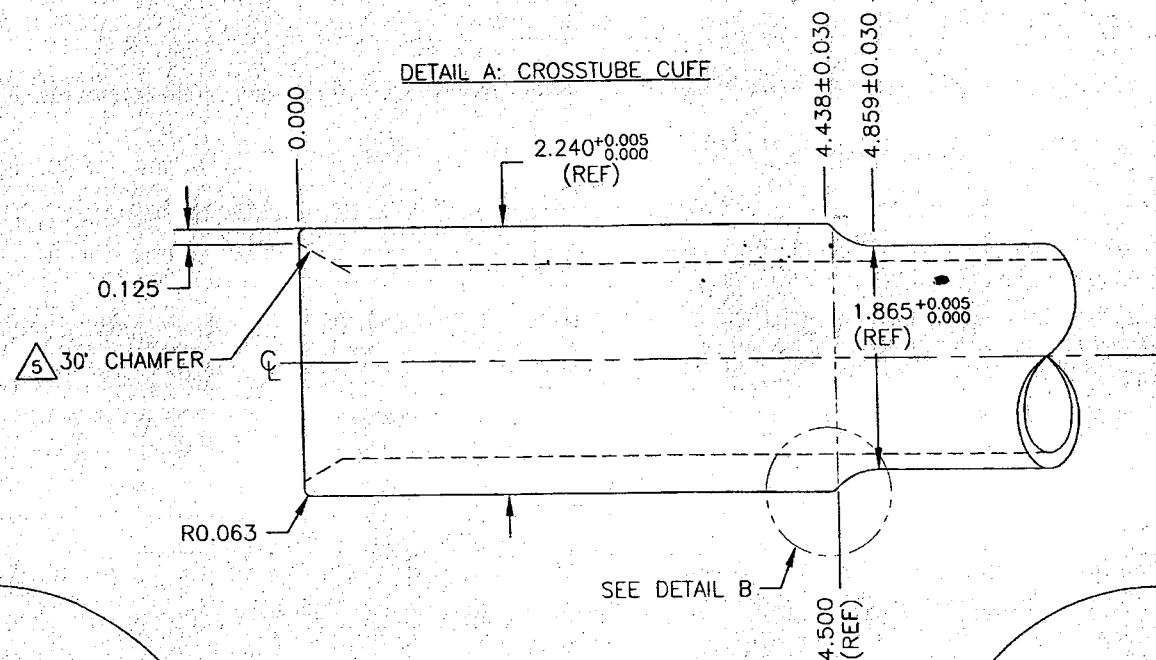


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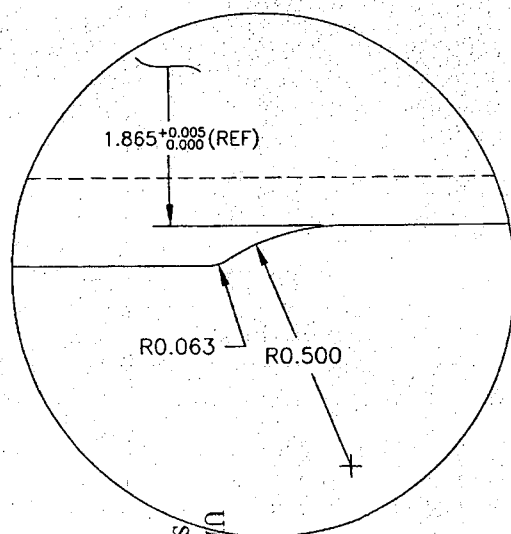
DESIGN PH	DRAWN BY PH	<b>DART</b> DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	REV. B
CHECKED # DS	APPROVED # DS	DRAWING NO. D407-667-145	SHEET 2 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (407 HIGH FWD)	SCALE 1:10

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WORK ORDER

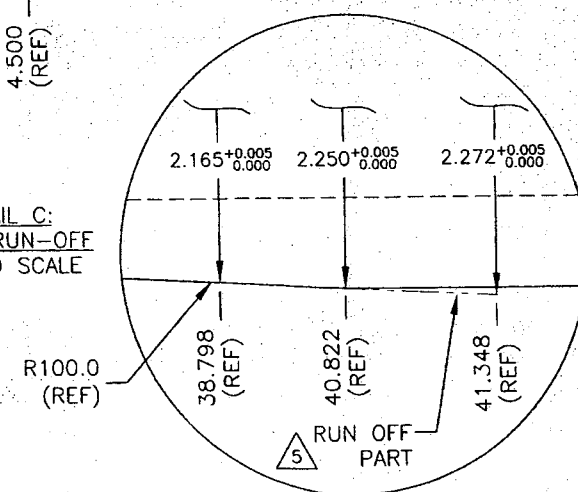


UNDER REVIEW  
 06.08.10  
 Ref. detail  
 07.08.10

05.07.16



DETAIL C:  
 TAPER RUN-OFF  
 NOT TO SCALE



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 WORK ORDER  
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 RETURN TO  
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		DATE 05.07.26		TITLE CROSSTUBE ASS'Y (407 HIGH FWD)	SCALE 1:1



Date: Friday, 3/30/2007 8:28:27 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 407 FWD X-TUBE  
 Job Number : 31553  
 Estimate Number : 12348  
 P.O. Number :  
 This Issue : 3/30/2007 S.O. No. :  
 Prsht Rev. : NC Part Number : D407667105  
 First Issue : 1 / Type : LANDING GEAR Drawing Number : D407-667-145 REVB  
 Previous Run : 31055 Project Number : N/A  
 Written By : Due Date : 4/5/2007 Qty: 1 Um: Each  
 Checked & Approved By :  
 Comment : Est Rev: R 05.09.01 Add holes for compatibility with Bell  
 Skidtubes KJ/JLM

## Additional Product

Job Number:

Seq. #:

Machine Or Operation:

Description:

1.0

DC

DOCUMENT CONTROL

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-105 CHG002

2.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

PULL FROM STOCK

1 X D407-667-105 B CHG001

1 X D407-667-105 B CHG001

3.0

D407667105

FWD Crosstube

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

FWD Crosstube

4.0

D2856400

Abrasion Strip

Comment: Qty.: 1.2138 f(s)/Unit Total : 1.2138 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400(Cut to 6.94") Abrasion Strip

5.0

D2873043

Nut Plate Assembly

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043 Nut Plate



# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-667 REV. C

REF. CANADIAN STC: SH01-5

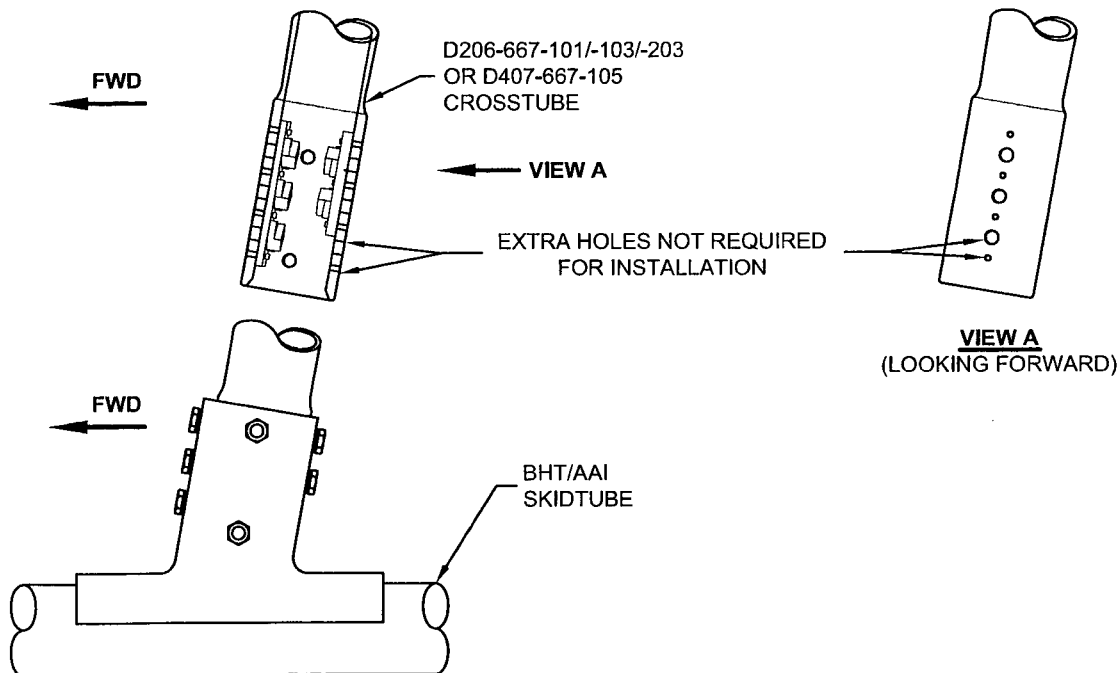
REF. FAA STC: SR01304NY

THE FOLLOWING D206-667-101/-103/-203 AND D407-667-105 CROSSTUBES HAVE EXTRA HOLES DRILLED ON THE AFT SIDE OF THE CUFFS. THIS HOLE IS NOT REQUIRED FOR INSTALLATION OF DART CROSSTUBES ONTO BHT/AAI SKIDTUBES AS SHOWN IN FIGURE 1.

CUSTOMERS RECEIVING CROSSTUBES AT CHG 002 PRIOR TO 06.08.08 SHOULD CONTACT DART FOR DISPOSITION IF INSTALLING THE DART CROSSTUBES ONTO BHT/AAI SKIDTUBES PER IIN-D206-667 REV. C.

CUSTOMERS RECEIVING CROSSTUBES AT CHG 002 PRIOR TO 06.08.08 TO BE INSTALLED WITH DART SKIDTUBES MAY FIND THAT THE SUPPORTS HAVE BEEN INSTALLED BACKWARDS. THE SUPPORTS SHOULD BE REMOVED AND RE-INSTALLED PER ICA-D206-667.

PART NO.	CHANGE NUMBER	BATCH NO
D206-667-101	002	B24244, B28679, B29261
D206-667-103	002	B26702, B26704, B27980, B25606, B25605, B23220, B23219, B23218, B23217, B28682, B28683, B32664
D206-667-203	002	B27492, B27491, B27981, B25609, B25608, B25006, B24646
D407-667-105	002	B31553



**FIGURE 1 - INSTALLATION OF DART CROSSTUBES ON BHT/AAI SKIDTUBE**

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01
<b>APPROVED</b> BY: <i>[Signature]</i> D. SHEPHERD (DE # 02)
DATE: 07.08.14 CERT. NO.: SH01-5 ISSUE NO.: 3

E	ADD D407-667-105 & B31553	MB	07.08.14
D	ADD B32664	MB	07.07.24
C	ADD B29261	MB	06.11.20
B	ADD B28679, B28682, B28683	PH	06.10.10
A	NEW ISSUE	PH	06.11.20
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>PH</i>		
CHECKED	<i>PH</i>	DRAWING NO.	REV. E
MFG. APPR.	N/A	DSI 9346	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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